

Date: Wednesday, 9/12/2007 12:17:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RING
Job Number : 34649	
Estimate Number : 10858	
P.O. Number : <u>N/A</u>	Part Number : D34075
This Issue : 9/12/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 33432	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 9/21/2007 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev A New Issue 05-11-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R3000	Inventory
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Comment: Qty.: 0.0306 f(s)/Unit Total : 0.6111 f(s)
 Material: 17-4ph SS Round Bar Ø3.000(M17-4-R3.000)
 Identify for D3407-5
 Batch: M18742

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Folio FA598 Rev: AA & Dwg D3407 Rev: C

2-Deburr

JL/J.F.

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/J.F.

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 07/08/18

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: _____

U 07-09-1816

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ QA: N/C Closed: _____ Date: 07/09/19

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/18	2	3 part are scrap because $\phi 2.050^{+0.012}_{-0.001}$ is 2.040"		Scrap, no replace cannot re-machine, parts are too thin.	J.F. 07/09/18			
07/09/18	2	1 part is scrap because de Rad of 1125" is too deep on the outside o.d.		Scrap, no re place.	J.F. 07/09/18			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 34649

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/21/09/19

Job Completion



u 0789.19

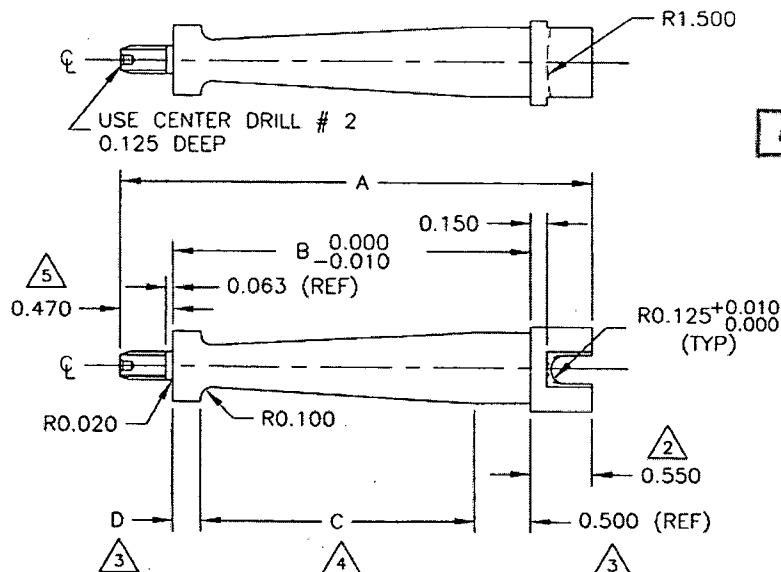
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

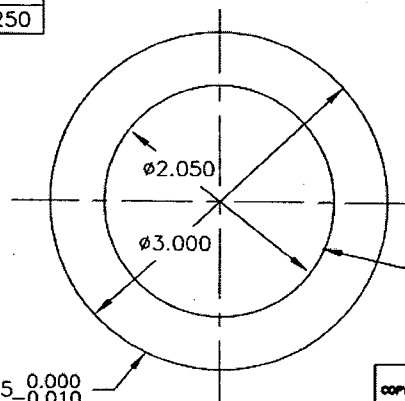
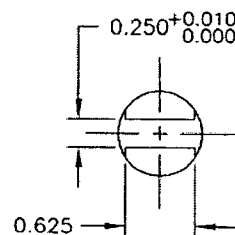
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

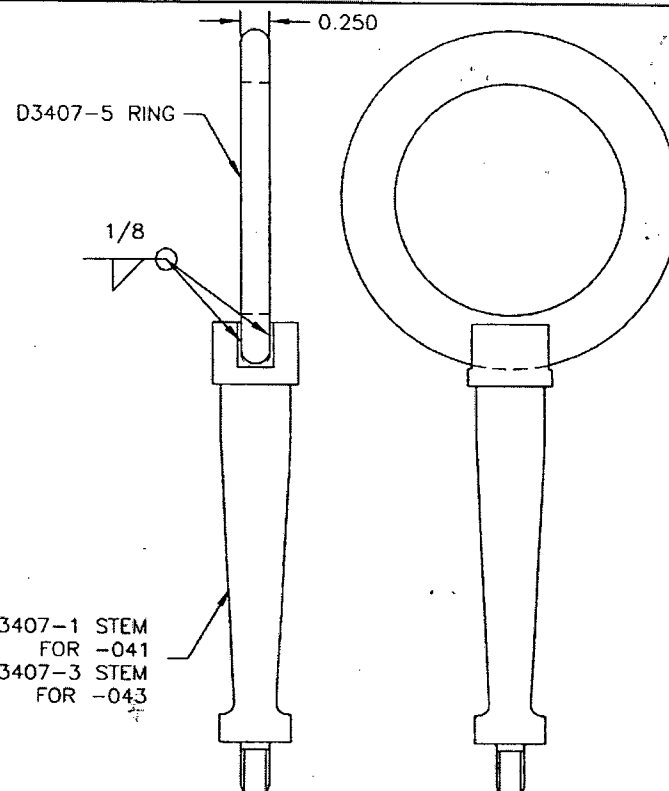
- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.09.12



D3407-5 RING



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DART AEROSPACE USA, INC.
DRAWN BY	CP	PORT WILSON, VA
CHECKED	APPROVED	DRAWING NO. D3407
DATE	05.09.09	TITLE TOW RING

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WITHOUT NOTICE
WORK ORDER
34649